

Page 1

Tuesday, August	30, 2011 8:4	49:58 AM ·			·						
Item ID: Revision ID:	D3198-1			Accept				s s	etup Star	t	
Item Name:	Fitting	. 12							Sto	p	
Start Date: Required Date:	8/30/2011 9/6/2011	Start Qty: \(\frac{1}{2}\)6.00 Req'd Qty: \(\frac{1}{2}\)00			Cust Item I Customer:	D:					
Reference:					•					1 (881)(81 81	
Approvals:	Process Pla	ın: MF	Date: 11-08-30	Tooling:	Da	ate:		R	un Star		
	QC:		Date:	<b>SPC (Y/N):</b>	Da	ate:			Sto	p	
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	rision Nbr									
D3198	Rev	A									
100 Waterjet		FLOW WATER JET	^	0.00 0.00				<u> B11-</u>	8-30		
FLOW CNC Waterje	t .	Memo I-Cut as p Deburr if r	er Dwg D3198		□2-					6	5
110		QC2- Inspect parts off	machine FAI/FAIB	0.00				PR. L.	8-36		
QC Quality Control		Memo		0.00							
120	·	QC8- Inspect parts - sec	cond check	0.00	· /			lausto	<b>,</b>	:	*
QC Quality Control		Memo		<sub>0.00</sub> $\triangle$ $\nu$	102/70			(×25	)		-

Dart A	\eros	pace	Ltd
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W/O:			WO	RK ORDER CHANG	GES					
DATE	STEP	PRO	CEDURE CHAN	IGE	В	y	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Cateç	gory:	NCR: `	es N	lo <b>DQ</b>	A:	Date: _	
	R	esolution:	Disposition	n:	QA: N/	C Clo	sed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (f	ICR)				
DATE	STEP	Description of NC			ction B		Verific	cation	Approval	Approval
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		gn & Date	Sect	ion C	Chief Eng	QC Inspector
		·								

Page 2

Insp.

Tuesday, August 30, 2011 8:49:58 AM Item ID: D3198-1 Accept Setup Start **Revision ID:** Stop Item Name: Fitting Start Qty: 6.00 **Start Date:** 8/30/2011 **Cust Item ID:** Required Date: 9/6/2011 Req'd Qty: 6.00 **Customer:** Reference: Run Start Process Plan: Approvals: Date: Tooling: Date: Stop QC: \_\_\_\_\_ Date: \_\_\_ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject **Work Center ID Description Run Hours** Code Qty **Qty** Number Stamp 130 0.00 NC BRAKE So ulator Brake NC 0.00 Brake NC 1-Deburr if necessary  $\Box$ 2-Form as per Dwg D3198 QC5- Inspect part completeness to step on W/O 140 OC Memo Quality Control Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 0.00

150

Powdercoat

Powder Coating

MM7334

25× 9 m/1/01/02

W/O:			WO	RK ORDER CHANG	ES		_		
DATE	STEP	PRO	OCEDURE CHAP	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No <b>DQ</b>	A:	Date:	
	R	esolution:	Disposition	າ:	_ QA: N/C C	osed:		Date: _	
NCR:			WORK ORDI	ER NON-CONFORMA	ANCE (NCF	R)			
DATE	STEP	Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		ion C	Chief Eng	QC Inspector
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#### Work Order ID 73275

Tuesday, August 30, 2011 8:49:58 AM



Page 3

Item ID:

D3198-1

Accept

Setup Start

Stop

**Revision ID:** Item Name:

Start Date:

Required Date: 9/6/2011

Fitting

8/30/2011

Start Qty: 6.00 Req'd Oty: 6.00

**Cust Item ID:** 

**Customer:** 

Reference:

**Approvals:** 

Process Plan:

Date:

Tooling:

Set Un/

**Run Hours** 

1-

Date:

Run Start



Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID

160

**Quality Control** 

Operation Description

QC: \_\_\_

OC3- Inspect Part Finish

Memo

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Reject

Insp. Number Stamp

Qty

170

Packaging

Packaging

Identify as per dwg & Stock Location

0.00

180

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

Memo

0.00

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W/O:			WO	RK ORDER CHANGI	ES			
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQA:	Date: _	· · · · · · · · · · · · · · · · · · ·
	R	esolution:	Disposition	ı:	_ QA: N/C Cld	osed:	Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR	)		
DATE	OTED	Description of NC		Corrective Action Section		Verificatio	n Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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### **Picklist Print**

Tuesday, August 30, 2011 8:49:52 AM

Work Order ID: 73275

D3198-1 Parent Item:

Parent Item Name: Fitting

Start Date: 8/30/2011

Required Date: 9/6/2011

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP: A□03.11.11□New Issue□KJ/RF□

IPP Rev:B Now on Waterjet 07-01-09 JLM

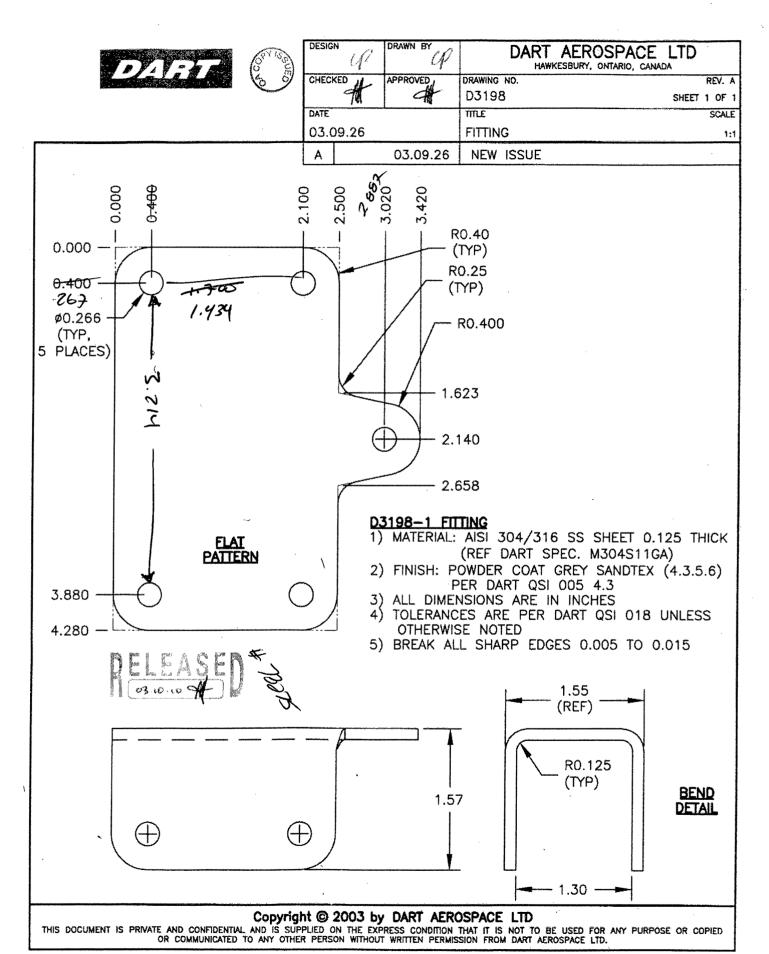
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	47.5000	0.105	0.663158	3		
							,			mi(-	91-211		

304/316 0.125 Sheet

Location Loc Qty Loc Code MAT020 47.5 117494 47.5



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W/O:			WO	RK ORDER CHANG	iES					
DATE	STEP	PRO	OCEDURE CHAN	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Categ	jory:	NCI	R: Yes	No <b>DQ</b>	A:	Date:	
	R	esolution:	Disposition	);	QA	N/C CI	sed:		Date: _	· <u> </u>
NCR:			WORK ORDE	ER NON-CONFORM	IANCE	(NCR	)			
DATE	STEP	Description of NC			ction B	Ö! 0	Verifi	cation	Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Sect	ion C	Chief Eng	QC Inspector
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W/O:		· · · · · · · · · · · · · · · · · · ·	W	ORK ORDER CHANGE	S				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Cate	egory:	NCR: Yes	No <b>DQ</b>	A:	Date: _	
	Re	esolution:	Disposition	on:	QA: N/C CI	osed:		Date: _	
NCR:		,	WORK ORD	ER NON-CONFORMA	NCE (NCF	l)			
DATE	STEP	Description of NC		Corrective Action Section			cation	Approval	Approval
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Sect	ion C	Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order:	7 3275
Description: Fitting	Part Number:	D3198-1
Inspection Dwg: D3198 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

		<del></del>				
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.266	+0.006/-0.001	836,	8		V 1802	
4.280	+/-0.010	4.289	>		ν	
2.500	+/-0.010	802.6	<b>&gt;</b>		V	
3.420	+/-0.010	3.421	2		ν	
0.400	+/-0.010	,400	0		V	
0.400	+/-0.010	-402	2		V	
3.880	+/-0.010	3.883	<b>&gt;</b>		٧	
2.100	+/-0.010	2.103	>		V	
3.020	+/-0.010	160.8	Э		V	
		1.				

Measured by:	B	Audited by:	$\sim$	Prototype Approval:	N/A
Date:	11-8-36	Date:	ulos/30	Date:	N/A

A 07.03.13 New Issue KJ/JLM	Approved	Revised by	Date Change	Rev
P 08 05 28 00 266 was 00 270		KJ/JLM ,	07.03.13 New Issue	Α
B 00.00.20   20.200 was 20.270   KJ/DD 20	<i>X</i>	KJ/DD	08.05.28 Ø0.266 was Ø0.270	В

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W/O:			W	ORK ORDER CHANGI	ES	-			
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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				<u> </u>					
Part No:				NCR: Yes No DQA: Date:					
Resolution:			Disposition: QA			A: N/C Closed: Date:			
NCR:		1	WORK ORE	DER NON-CONFORMA	NCE (NC	R)		٠.	. 4
DATE	STEP	Description of NC Section A		on B	Verifica		Approval	i Approval	
			Initial Chief Eng	Action Description Chief Eng	Sigr Dat	loc Sec	Section C	Chief Eng	QC Inspector
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